

Work Order ID 71102

Wednesday, June 22, 2011 2:32:15 PM

Page 1

Item ID: D2056

Accept

Setup Start

Revision ID:

Stop

Item Name: Bell Crank

Start Date: 6/22/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2056

Rev B2

100

0.00



BAND SAW

0.00

Bandsaw

Memo

Jeaspa Bandsaw

Cut blanks 2.80" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

Machine as per folio D2056

Tumble
Deburr

120

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check

0.00



QC

Memo

0.00

OK 11/6/28

12

Quality Control

140 Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

12

Hand Finishing

150 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

*11:00
220
11:30*

12

Powder Coating

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 12.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				12	6	11/06/29	
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo	0.00 0.00		SB	11/07/05	(12)			
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/7/5	MF 11-07-05

Picklist Print

Wednesday, June 22, 2011 2:32:12 PM

Page 1

Work Order ID: 71102

Parent Item: D2056

Parent Item Name: Bell Crank



Start Date: 6/22/2011

Required Date: 6/30/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP E02.04.04 Added Rev.B2 NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	19.4760	0.2375	2.79996			



6061-T6 Bar 1.25 x 1.25



Location

Loc Qty

Loc Code

MAT003

19.476

116135

1.68

✓ 117798

17.796

2.7999 €

S.A 11/06/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

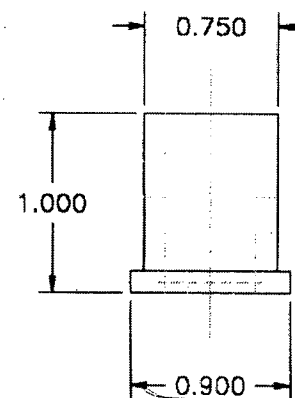
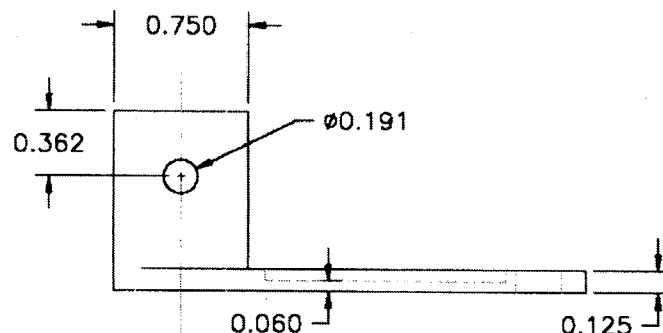
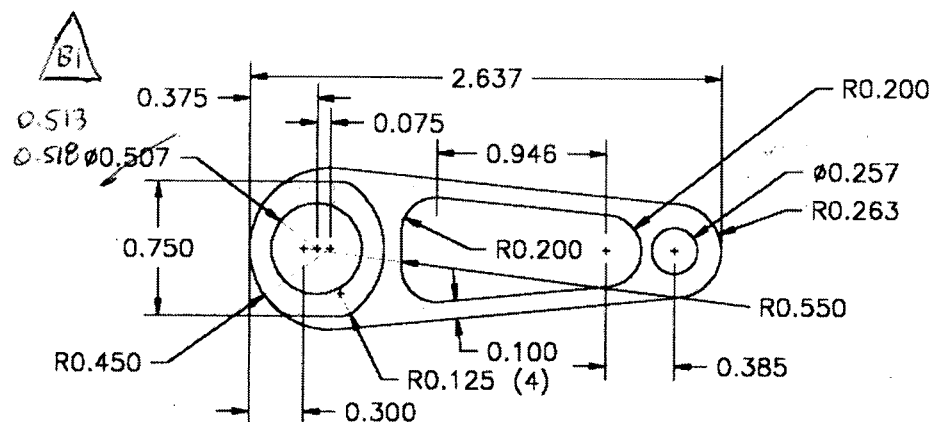
NOTE: Date & initial all entries

DART



RELEASED
99.04.29 14E

DESIGN	B WILLIAMS	DRAWN BY	K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2056
DATE	92.03.13	TITLE	BELL CRANK	REV. B
		SCALE	1:1	SHEET 1 OF 1
B	95.11.02	RE-DESIGN		
B1	01.06.04	MODIFY HOLE SIZE, ADD FILE OF 7mm		
B2	01.12.20	ADD NOTE ON TOLERANCES		



WTO 71102

B1 ACID ETCH + ALDOME PER
DART QSI COS 4.1
POWDER COAT BLACK SINTER
(4.3.5.7) PER DART
QSI COS 4.3

B2

MATERIAL: 6061-T6 (QQ-A-225/8)
FINISH: ANODIZE (BLACK) OR
TOLERANCES ARE PER DART QSI OR UNLESS OTHERWISE NOTED

DART AEROSPACE LTD		Work Order: 71102
Description: Bell Crank		Part Number: D2056
Inspection Dwg: D2056	Rev: B2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/-0.010	0.751	✓		Vern	GA-01
0.900	+/-0.010	0.900	✓		"	"
1.000	+/-0.010	1.007	✓		"	"
0.125	+/-0.010	0.128	✓		"	"
0.060	+/-0.010	0.058	✓		Mic	GA-03
Ø0.191	+0.005/-0.001	Ø0.192	✓		Vern	GA-01
0.362	+/-0.010	0.357	✓		"	"
0.750	+/-0.010	0.751	✓		"	"
0.385	+/-0.010	0.385	✓		"	"
Ø0.257	+0.006/-0.001	Ø0.259	✓		"	"
0.100	+/-0.010	0.100	✓		"	"
0.300	+/-0.010	0.300	✓		"	"
0.946	+/-0.010	0.946	✓		"	"
0.075	+/-0.010	0.075	✓		"	"
2.637	+/-0.010	2.637	✓		"	"
0.375	+/-0.010	0.375	✓		"	"
Ø0.513-0.518	0.513 - 0.518	Ø0.516	✓		R-6	ref.
R0.450	+/-0.010	R0.450	✓		"	"
R0.125	+/-0.010	R0.125	✓		"	"
R0.200	+/-0.010	R0.200	✓		"	"
R0.550	+/-0.010	R0.550	✓		"	"
R0.263	+/-0.010	R0.263	✓		"	"

Measured by: H.A	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11/06/27	Date: 11/06/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD	
B	10.02.02	Dimensions revised	KJ	[Signature]

